Work Order I Tuesday, July 19, 20	•									Page 1
	162-3		Accept				Setup	Start		
Revision ID: Item Name: Lug								Stop		
	9/2011 Start Qty: 8.00			Cust Item I Customer:	D:					
Reference:	•		•							
Approvals: Pro	ocess Plan:	Date: //-07-/	Tooling:	Da	nte:		Run	Start	 	
QC	C:	Date:	SPC (Y/N):	Da	ıte:			Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool# Pl	an Acc		ject y	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									<u>.</u>
D3462	Rev C									
	FLOW WATER JET		0.00			f	B11- 8-	3		
Waterjet FLOW CNC Waterjet 384 .37 5 x 3	Memo 1-Cut as p Deburr if r	er Dwg D3462 Dwg Re lecessary	0.00 v:□Prog Rev:_	<u> </u>	Š	254	68/1	/	8	
110	QC2- Inspect parts off	machine FAI/FAIB	0.00							
QC Quality Control	Memo		0.00				B11-8-	3		
120	QC8- Inspect parts - se	cond check	0.00 Sul	ocli7		(.	(3)			
QC Quality Control	Memo		0.00	11						

۲.

W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	0	ate Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u> </u>			
Part No	·	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA:	Date: _	
	Res	olution:	Disposition	n:	QA: N/C	Close	ed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC	ction B		Verificatio	n Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	ption Sign & Date		Section C	Chief Eng	QC Inspector

Work Order ID 72161

Tuesday, July 19, 2011 1:50:11 PM



Page 2

Item ID:

D3462-3

Accept

Setup Start

Revision ID:

Item Name: Lug

Required Date: 7/25/2011

7/19/2011

QC:

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ **Work Center ID**

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location: 14

Memo

Memo

*****STOCK IN LARGE FAB*****

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number

Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

NIV08-19

- 411.7101	oopaoo									
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								
Part No	:	PAR #:	Fault Cate	jory:	_ NCR:	Yes N	lo DQ	A:	_ Date: _	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC Corrective Action						cation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign & Date				Chief Eng	QC Inspector
						٠				
<u>, </u>										
	1								1 ·	

Picklist Print

Tuesday, July 19, 2011 1:50:17 PM

Work Order ID: 72161

Parent Item: D3462-3

Parent Item Name: Lug



Start Date: 7/19/2011

Required Date: 7/25/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV. A 05.11.18 NEW ISSUE EC

IPP Rev:B Now on Waterjet 06-06-16

JLM esr rev B 08.07.15 ecn 1049 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	5.0000	0.266	2.24		* #*****	<u></u>
M304 SS bar .375 x 3.00										13	11-8-3		

Location Loc Code Loc Qty MAT050 5

> 115389 5

W/O:			WC	RK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·	•	
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	\:	_ Date: _	
		solution:							
NCR:		,	WORK ORD	R NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC	Description of NC Corrective Action		Verific			Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
		·							

D3065-5DART AEROSPACE LTD	Work Order:	72161
Description: Lug	Part Number:	D3462-3
Inspection Dwg: D3462 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	. 249	4		V B02	
2.13	+/-0.030	7.131	2		V	
2.55	+/-0.030	2,552	*		V	
R0.55	+/-0.030	,55	X		R.G	
R0.50	+/-0.030	50	7		R.G	
1.98	+/-0.030	(.978	2		V	
0.375	+/-0.010	,371	ð		V	
				j		

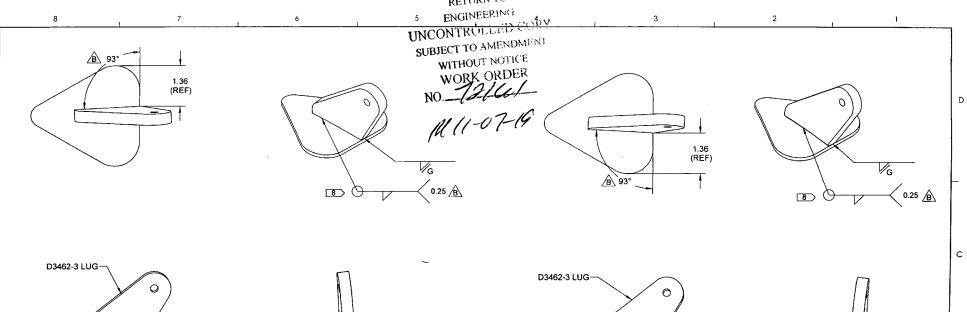
Measured by:	Audited by:	Prototype Approval:	N/A
Date: ((~%~~3	Date: (1/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.06.27	New Issue	KJ/JLM 1.A	
В	08.07.24	Dwg Rev updated	KJ/DD	7

W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u> </u>		
		i							
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCI	7)			
DATE	STEP	Description of NC	Corrective Action Section B			& Verifi	cation	Approval	Approval
DAIL	O.L.	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng			ion C	Chief Eng	QC Inspector
		· · · · · · · · · · · · · · · · · · ·							
1	1	1	1 1		l l	ı		1	1

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY RETURN TO



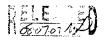
D3462-041 BRACKET ASSEMBLY

QTY -041 X	-042	P/N D3462-041	DESCRIPTION BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED

- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042"
 USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.75 lbs (TYP)
 8) WELDING: PER DART QSI 004

D3462-042 BRACKET ASSEMBLY



	11000	IV. PRODUCTION	*TAGILIST		1 1			
В	REVISE	DIMENSIONS		RF	05.12.05			
Α	NEW IS	SUE		RF	05.09.20			
REV.	DESCR	IPTION		DATE				
DESIG	N	_ , }	DART AEROSPA	DART AEROSPACE LTD				
DRAW	N	MAN DC	HAWKESBURY, ONTARIO, CANADA					
CHEC	KED	NP	DRAWING NO.		REV. C			
MFG.	APPR.	\mathcal{A}	D3462		SHEET 1 OF 2			
APPRO	OVED	100	TITLE		SCALE			
DE AP	PR.	-#	BRACKET ASSEMBLY COPYRIGHT © 2005 BY DART AEROSPACE LTD Inst document is when it aw complemia, and is supplied on the Express controls that not to be used not any supplies concerned complement complements to other preservations.					
DATE	07.1	10.24						

3

SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG

8

D3462-1 BASE

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7

5

D3462-1 BASE

DC 07.10:24

W/O:		, ,, , , , , , , , , , , , , , , , , , ,	W	ORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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										i
Part No:		PAR #:	Fault Cat	NCF	NCR: Yes No DQA: Date:					
						QA: N/C Closed: Dat				
NCR:		\	NORK OR	DER NON-CONFOR	RMANCE	(NCR))			
DATE	STEP	Description of NC Section A	Corrective Action Section				Verific	cation	Approval	Approval
			Initial Chief Eng	Action Description	on	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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	1						1			1

8 - 3.58 R0.55 - 0.375 D D Ø0.257 (DRILL "F") \oplus Ę 3.36 1.98 🕭 R0.50 R20.0±0.1 62° ß CHAMFER (TYP) R0.82 **D3462-1F FLAT PATTERN** D3462-3 LUG (TYP) - R20.0±0.1 NOTES:
1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.47 lbs D3462-1 BEND DETAIL (MAKE FROM D3462-1F) NOTES: 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S11GA) 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DESIGN DART AEROSPACE LTD 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. 6) IDENTIFICATION: NONE 7) WEIGHT: 0.28 lbs CHECKED REV. C D3462 MFG. APPR SHEET 2 OF 2 TITLE APPROVED SCALE **BRACKET ASSEMBLY** DE APPR. COPYRIGHT 6 2005 BY DART AEROSPACE LTD
7% DOCUMENT IS PRIVITE AMCCONTRESTINA AND IS SURVE GO ON THE ELEMENTS CONTROL
NOT TO BE USED FOR ANY PURPOSE OF COMETO ACCOUNTANCE TO TO ANY OTHER PRISON
WRITTEN PRISONS SON FROM DART AEROSPACE LTD DATE 07.10.24 5 8 7 4 3 . 2

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·	,			
		,							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	\ :	Date:	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Section B Sign &		cation on C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
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